

**Work Order ID 63343**

Wednesday, October 27, 2010 4:01:07 PM

Page 1

Item ID: D3389-1

Accept:

Revision ID:

Item Name: Web

Setup Start

Stop

Start Date: 10/27/2010 Start Qty: 2.00

Required Date: 11/11/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: HDate: 10/28

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3389

Rev D

100



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1- Pick D2500-3-100

2- Deburr

3- Locating from deburred end, drill pilot holes using DT8785 as per dwg

D3389. Scribe cut line.

4- Cut to finished length

5- Open holes to finished size as per dwg D3389

6- Deburr

110



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

10-12-7

2 0 BE 10/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 63343

Wednesday, October 27, 2010 4:01:07 PM



Page 2

Item ID: D3389-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

120



HandFinish

Hand Finishing

Operation  
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Memo

0.00

~~BE~~  
10-12-08

②

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

SAD  
10-12-08

Memo

0.00

②

140



Packaging

Packaging

Identify as per dwg & Stock Location:

LG

0.00

Memo

0.00

②

BE 10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 63343**

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Page 3

Item ID: D3389-1

Revision ID:

Item Name: Web

Start Date: 10/27/2010 Start Qty: 2.00

Required Date: 11/11/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

0.00

10/12/08  
MAF  
10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 4:01:10 PM

Page 1

Work Order ID: 63343

Parent Item: D3389-1

Parent Item Name: Web



Start Date: 10/27/2010


Required Date: 11/11/2010

Start Qty: 2.00

Required Qty: 2.00

## Comments:

IPP Rev: A 05.08.31 New issue KJ/JLM  
 IPP Rev: B 06-02-08 As per Rev C JLM  
 IPP Rev: C 07-11-13 ECN 1056 Rev D dwg DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100 		Manufactured	No			100	Each	75.0000	1	2			

Ext'n -I Beam Web 4"

## Location

## Loc Qty

## Loc Code

LG

75

51957

75

2 8 ERO/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

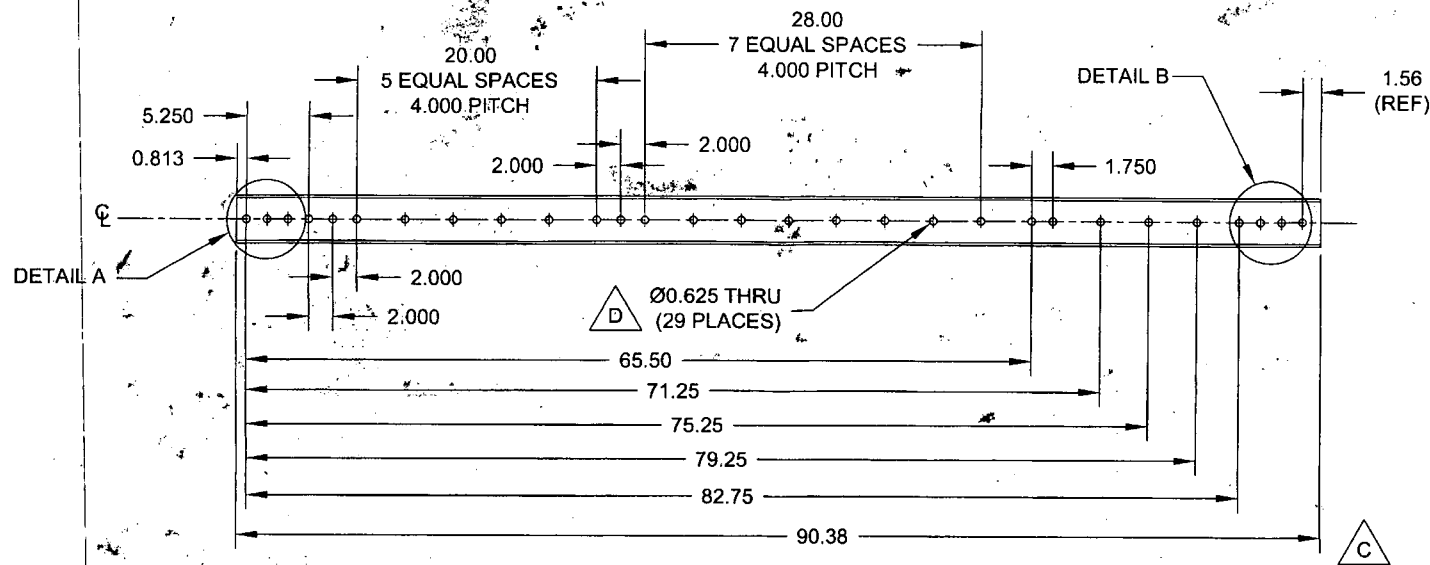
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

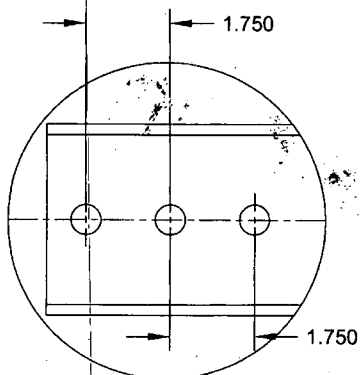
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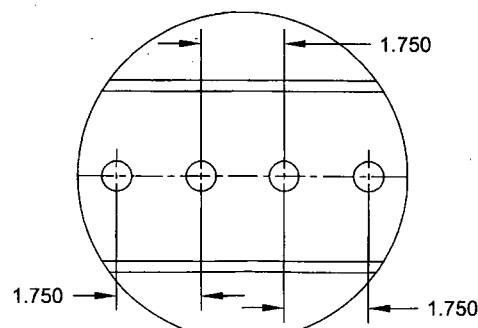




**D3389-1 412 WEB**



**DETAIL A**  
SCALE 2:5



**DETAIL B**  
SCALE 2:5

**NOTES:**

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

**RELEASED**  
07.11.06 MJD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63343

2/10/10.21

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4: REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		
<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA DRAWING NO. D3389 TITLE 412 WEB SCALE 1:10 COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

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